

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004978**Date Inspected:** 01-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2200**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island**Location:** Changxing Island, Shanghai**CWI Name:** Wu Bin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) representative was present for observations relative to fabrication performed by Zhenhua Port Machinery Company (ZPMC) for the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Changxing Island, in Shanghai, China. While on site the QA Inspector noted the following:

OBG floor beam.

1. The QA Inspector performed a random Visual (VT) and Magnetic Particle Testing (MT) verifications on the completed welds made between assembly component members on the inspection part number: FB004-019, FB013-025, FB014-029, FB014-027, FB013-023, FB013-027, FB013-022, FB013-018, FB005-020, FB005-021, FB005-022, FB005-024, FB004-017 and FB014-019 of the OBG floor beam section (please note that multiple welds were verified on this inspection parts). Please refer to the ZPMC Non Destructive Examination (NDE) notification of witness inspection document number 001520 item numbers 2 to 15 for weld numbers and additional information. Please note that the VT and MT verifications were performed on these welds as a request for the tagging in process of the assemblies and not for final verification. The QA Inspector performed the verifications on these welds after ZPMC Quality Control Inspection personnel had completed the inspections and reported the welds to be acceptable and ready for verification. The QA Inspector did not observe any welding related discontinuities and did not observe any relevant indications during verifications. The QA Inspector notified QC Inspector Wu Bin and Lead QA Inspector Paul Dawson of the observations during verifications. Please see the QA Inspector's Magnetic Particle Testing (TL 6028) report generated on this date for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

OBG floor beam.

2. The QA Inspector was requested to perform MT verification on completed welds made between assembly component members on the inspection part numbers shown on the ZPMC notification of witness inspection document number 001512 item numbers 1 to 8. At the time of arrival at the bay number 7, the QA Inspector could not locate the inspection parts and requested ZPMC QC Inspection personnel to provide support to find these inspection parts. ZPMC QC Inspector Wu Bin notified the QA Inspector the inspection parts shown on the document could not be verify at this moment at this location due to the fact that the inspection parts area not longer in the bay 7 and that QC Inspector did not know where those part were located. The QA Inspector notified Lead QA Inspector Paul Dawson of issue mentioned above.

Summary of Conversations:

As noted in the body of the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (1500) 129-9593, who represents the Office of Structural Materials for your project.

| | | |
|----------------------|----------------|-----------------------------|
| Inspected By: | Medina,Ricardo | Quality Assurance Inspector |
|----------------------|----------------|-----------------------------|

| | | |
|---------------------|----------------|-------------|
| Reviewed By: | Carreon,Albert | QA Reviewer |
|---------------------|----------------|-------------|
